

**Amendments to the Claims:**

This listing of claims will replace all prior versions, and listings, of claims in the application:

**Listing of Claims:**

1-23. (Canceled.)

24. (Previously Presented) A method of providing lubricity in a forming or machining fluid, comprising the steps of:

providing a forming or machining fluid;

providing a boron compound; and

mixing the boron compound in the forming or machining fluid at a concentration of from about 2% to about 24% by weight;

wherein

the boron compound is boric acid;

the boron compound is in the form of a nanometer-sized particulate and;

the forming or machining fluid is selected from the group consisting of n-alcohols, polyalkyleneglycols, polyvinyl alcohol, glycerol, and combinations of any two or more thereof.

25-29. (Canceled.)

30. (Previously Presented) The method of claim 24, further comprising the step of dissolving the boron compound in a solvent before mixing with the forming or machining fluid.

31. (Currently Amended) The method of claim 30, wherein the solvent is selected from the group consisting of methanol, ethanol, isobutyl alcohol, pyridine, isoamyl alcohol, n-propanol-alcohol, alcohol, 2-methylbutanol, glycerol, lactate esters and combinations thereof.

32. (Previously Presented) The method of claim 24 wherein the method further comprises spraying, roll-coating or dipping a metal substrate in the forming or machining fluid.

33. (Previously Presented) The method of claim 32 wherein the forming or machining fluid and the boron compound are introduced simultaneously within an applicator for the purpose of metering the amount or concentration of the forming or machining fluid onto a substrate via a spray application.
34. (Canceled.)
35. (Previously Presented) The method of claim 24 wherein glycerol or a polyalkylene glycol is the forming or machining fluid.
36. (Previously Presented) The method of claim 32, further comprising drying the forming or machining fluid to a dry film to provide cooling and lubrication in metal parts stamping operations.
37. (Previously Presented) The method of claim 32 further comprising drying the forming or machining fluid to a dry film wherein the dry film is capable of being removed with a cold water rinse after a metal forming operation.
- 38-43. (Canceled.)
44. (Previously Presented) The method of claim 24, wherein the forming or machining fluid is a drilling mud.
45. (Canceled.)
46. (Canceled.)
47. (New) A method of providing lubricity in a forming or machining fluid, comprising the steps of:
  - providing a forming or machining fluid selected from the group consisting of polyalkyleneglycols, polyvinyl alcohol, glycerol, and combinations of any two or more thereof;
  - dissolving boric acid in a solvent selected from the group consisting of methanol, ethanol, isobutyl alcohol, pyridine, isoamyl alcohol, n-propanol, 2-methylbutanol, glycerol, lactate esters and combinations thereof; and

mixing the solvent and dissolved boric acid in the forming or machining fluid at a concentration of from about 2% to about 24% by weight.

48. (New) The method of claim 47, wherein the forming or machining fluid is selected from the group consisting of polyalkyleneglycols, polyvinyl alcohol, and a combination thereof.
49. (New) The method of claim 47, wherein the solvent is methanol.
50. (New) A method of providing lubricity in a forming or machining fluid, comprising the steps of:
  - preparing a concentrated solution of boric acid in a forming or machining fluid selected from the group consisting of cellulose, polyalkyleneglycols, polyvinyl alcohol, glycerol, and combinations of any two or more thereof;
  - and
  - adding water to the concentrated solution.
51. (New) The method of claim 50, wherein the boric acid is present from about 2% to about 24% by weight.